

Work Order ID 51213

August 10, 2009 8:59:29 AM

Page 1

Item ID: D3319-3

Accept

Revision ID: B

Item Name: Wearplate

Start Date: 8/10/09 Start Qty: 12.00

Required Date: 8/14/09 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

09-08-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3319

Rev B

12

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 9-8-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-8-11

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 8 08/08/10

(12) 8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51213

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Page 2

Item ID: D3319-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 8/10/09 Start Qty: 12.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
	<i>u/AS</i>								
140		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form using DT8326 & DT8261 as per Dwg D3319Rev: <i>B</i>								
	<i>SB 09/03/13</i>								
150		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control									
	<i>=> 8 09/03/13</i>								
	<i>(470) 6</i>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

Item ID: D3319-3

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Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 8/10/09 Start Qty: 12.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Large Fab	Large Fab	0.00							
	Memo	0.00							
	Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: <div> <input type="checkbox"/> Qty Part Number Description Batch <input type="checkbox"/> A/R </div> <div> N/A 7560 Hardcoat Rod <u>M109060</u> </div>								
170 QC	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
180 QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							

EL 9-8-19 (X12)

⇒ 8/08/09

(X12) φ

⇒ 8/08/09

(X12) φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51213
Description: Wearplate		Part Number: D3319-3
Inspection Dwg: D3319	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

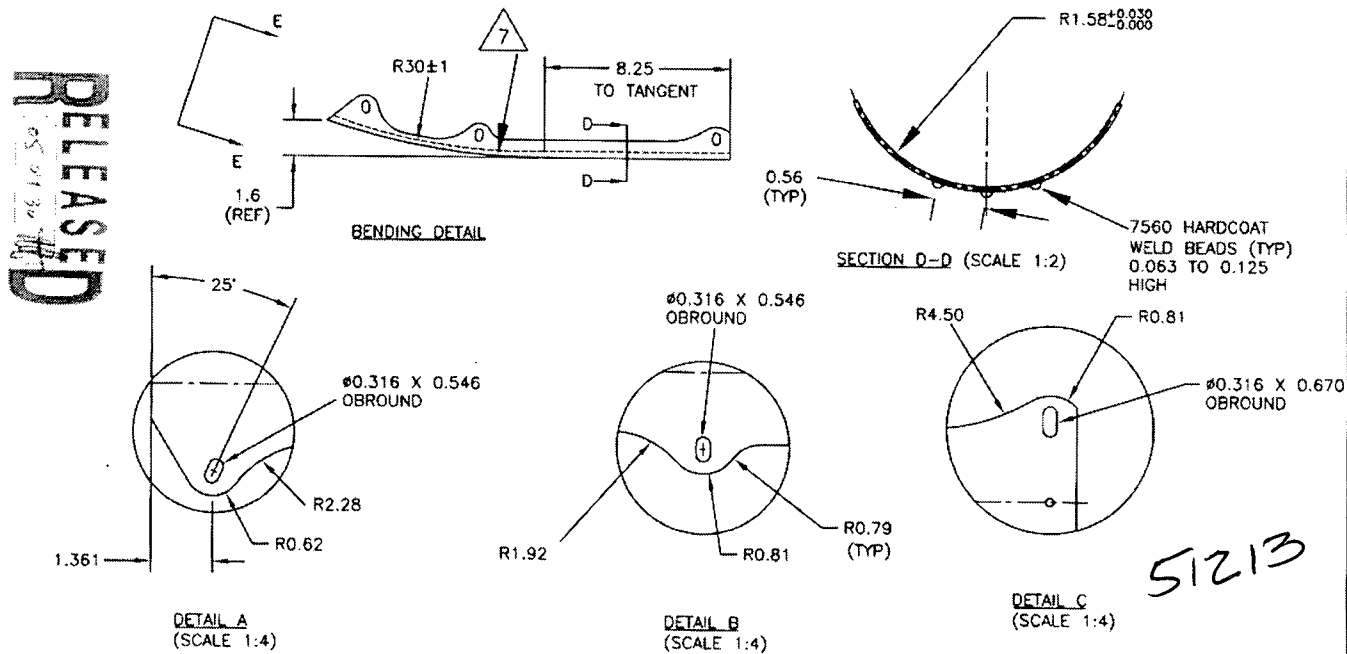
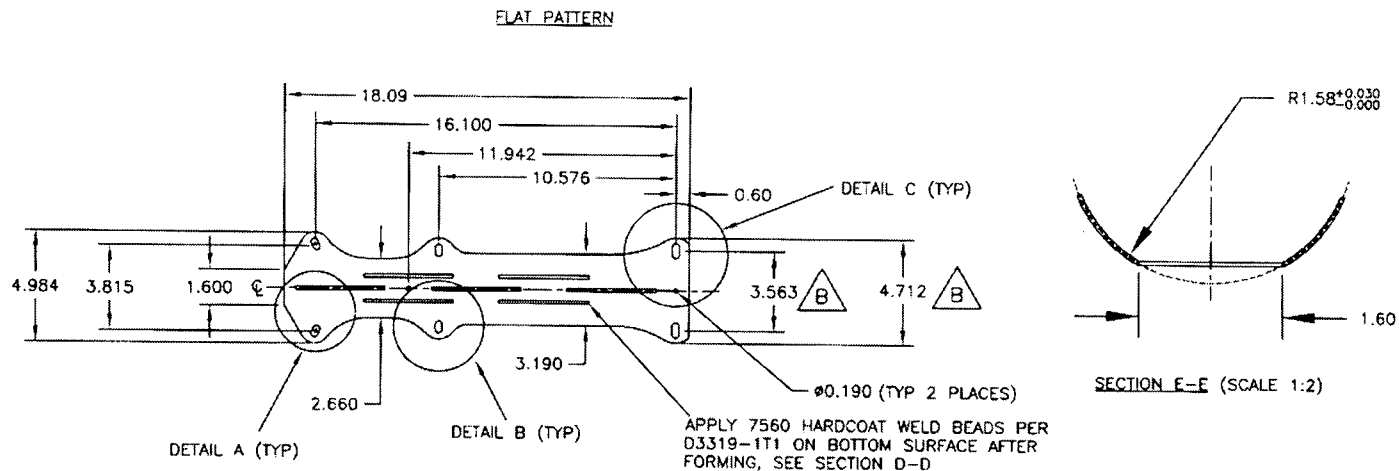
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	X			
74.420	+/-0.010	74.420	✓			
62.770	+/-0.010	62.770	X			
52.890	+/-0.010	52.890	X			
30.790	+/-0.010	30.790	X			
8.690	+/-0.010	8.688	X			
0.60	+/-0.030	0.600	X			
2.690	+/-0.010	2.689	X			
2.940	+/-0.010	2.949	X			
3.527	+/-0.010	3.526	X			
4.518	+/-0.010	4.515	X			
Ø0.190	+0.005/-0.001	0.192	X			
2.940	+/-0.010	2.949	X			
2.940	+/-0.010	2.947	X			
2.690	+/-0.010	2.696	X			
5.063	+/-0.010	5.059	X			
6.163	+/-0.010	6.162	X			
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	318 x 611	X			
0.048	+/-0.010	0.048	X			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-8-11	Date: 9/18/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	B

DART



D3319-1 WEARPLATE

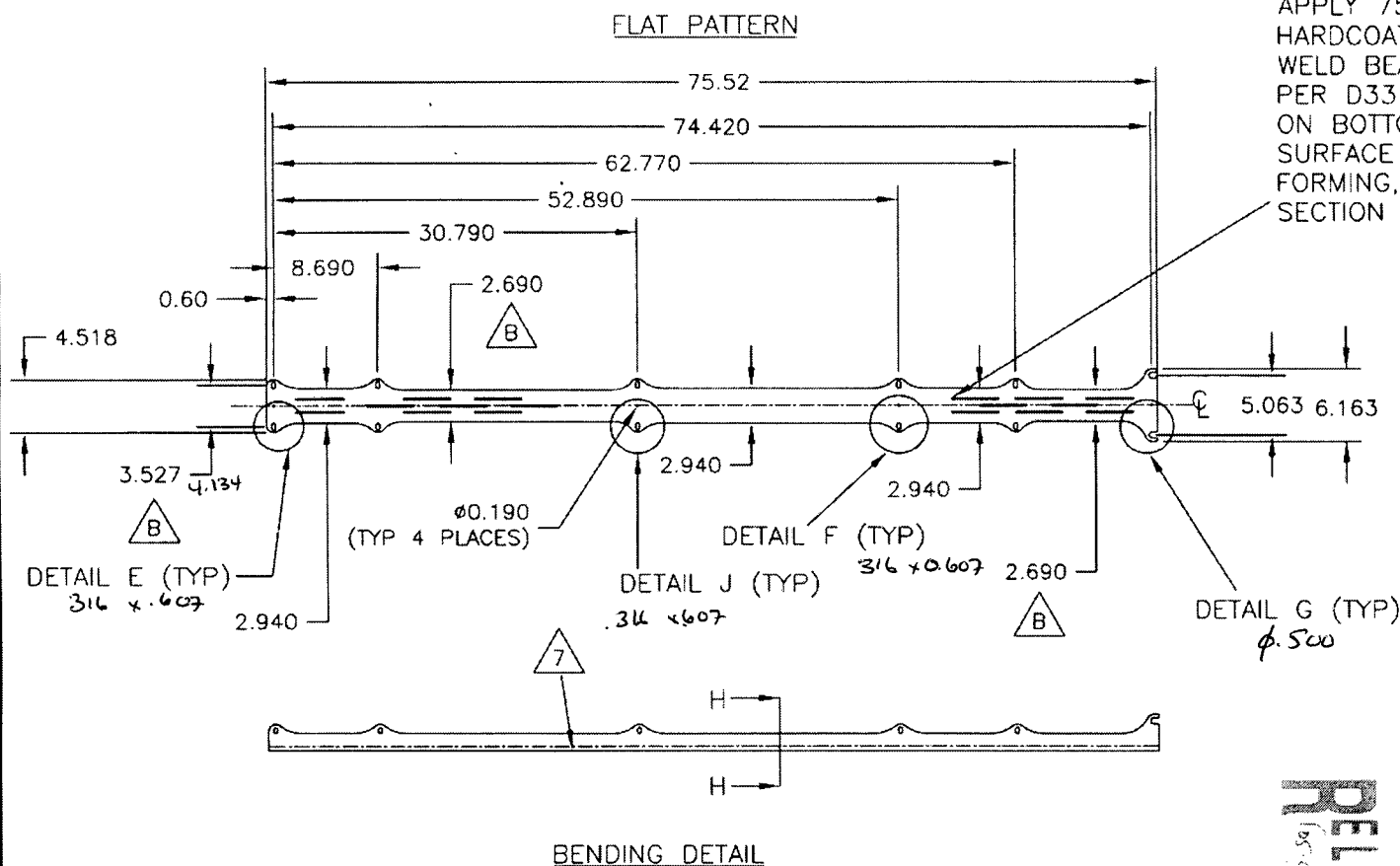
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-16"

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH1	84	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SHEET 1 OF 5
05.06.06	WEARPLATE	SCALE 1:8
REV	DATE	DESCRIPTION
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

RELEASED
05/01/30

DART

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



DESIGN	DART	DRAWN BY	DART	DART AEROSPACE LTD
CHECKED	07	APPROVED	07	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 2 OF 5
				SCALE 1:15

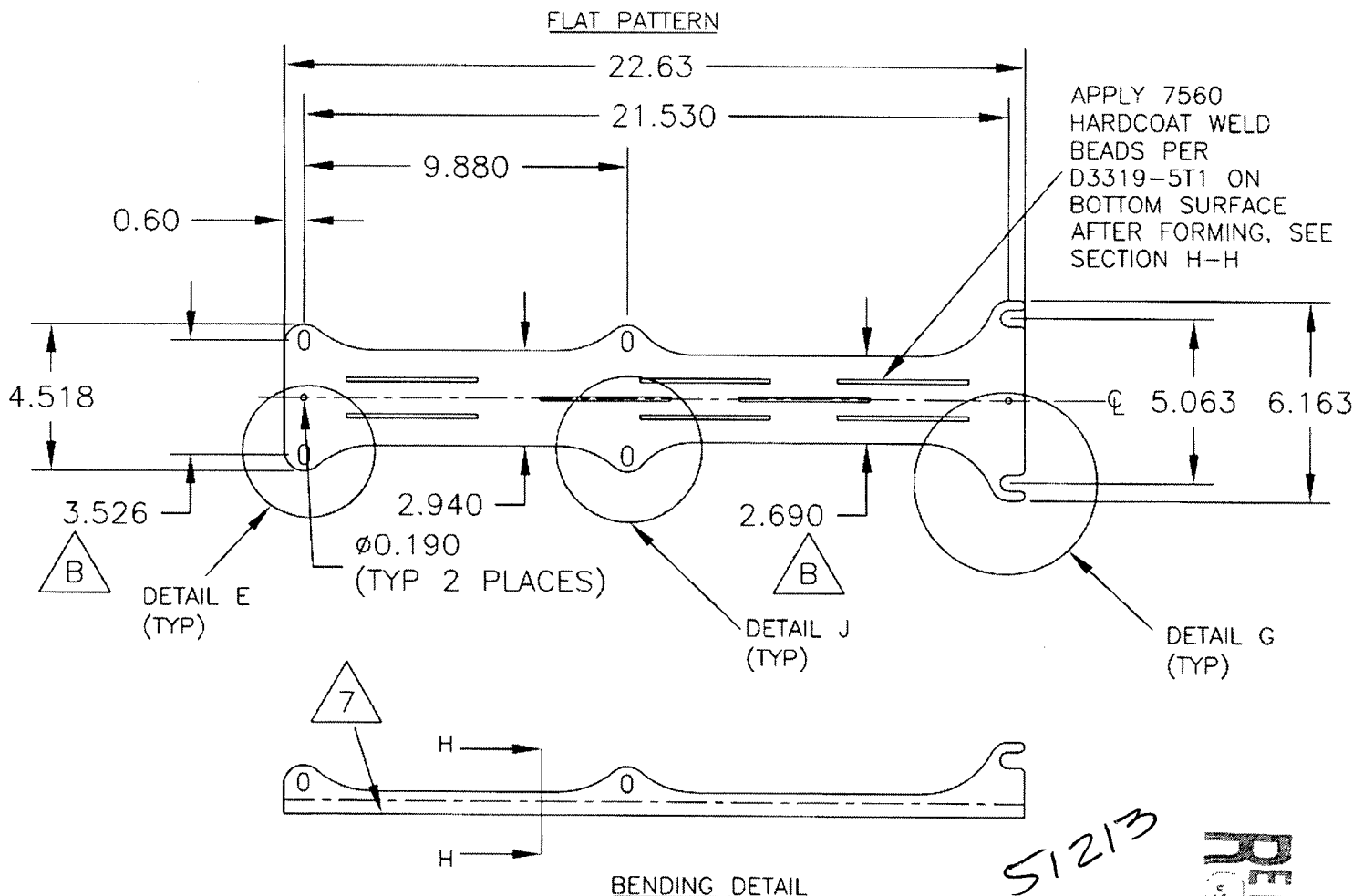
RELEASED

51213

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

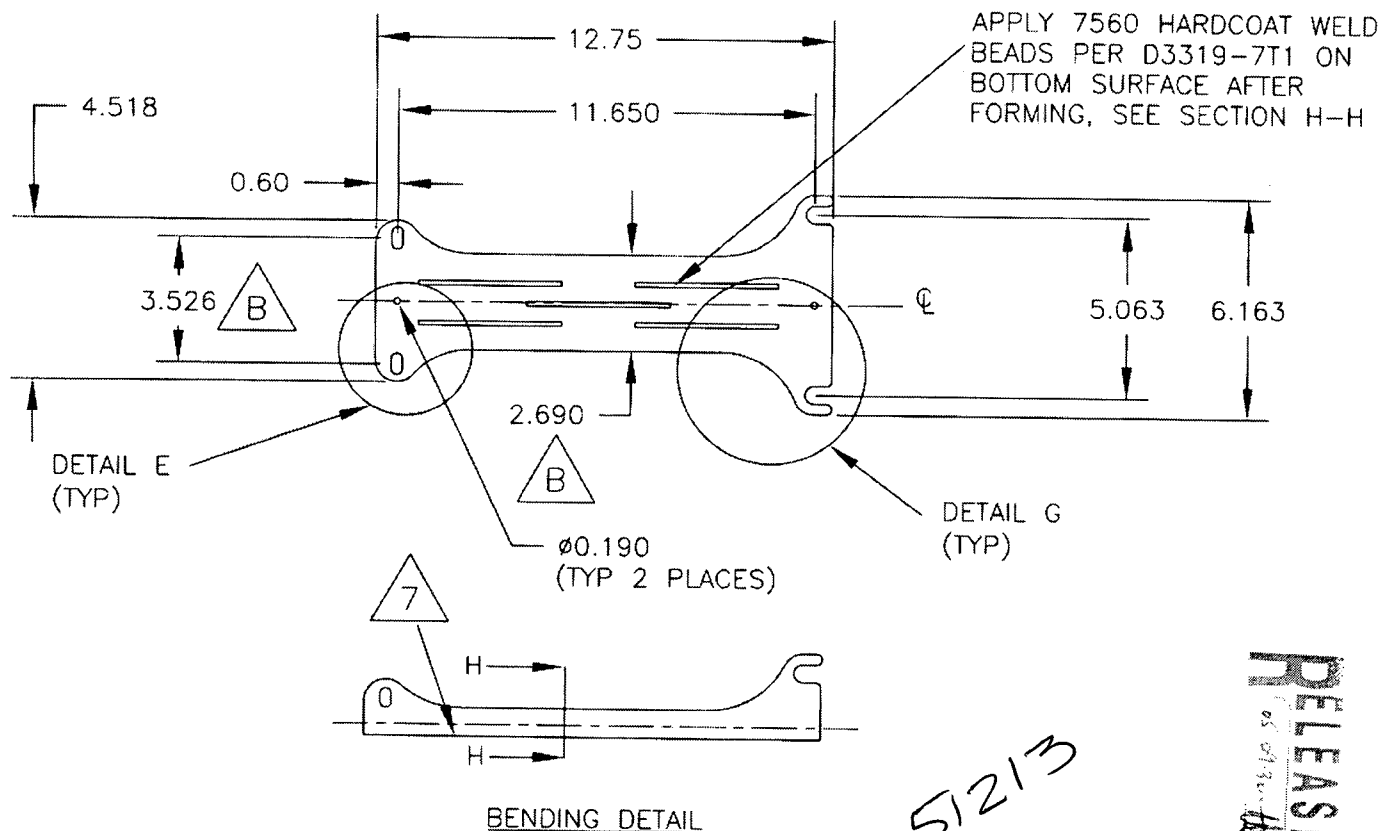
RELEASED
US 67 30 11

DESIGN	D31	DRAWN BY	D31	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	REV. B
DATE	05.06.06	DRAWING NO.	D3319	SHEET 3 OF 5
		TITLE	WEARPLATE	SCALE 1:5

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	CH	APPROVED	CH	DRAWING NO.	REV. B
DATE	05.06.06			D3319	SHEET 4 OF 5
				TITLE	SCALE
				WEARPLATE	1:5

FLAT PATTERN



51213

D3319-7 WEARPLATE

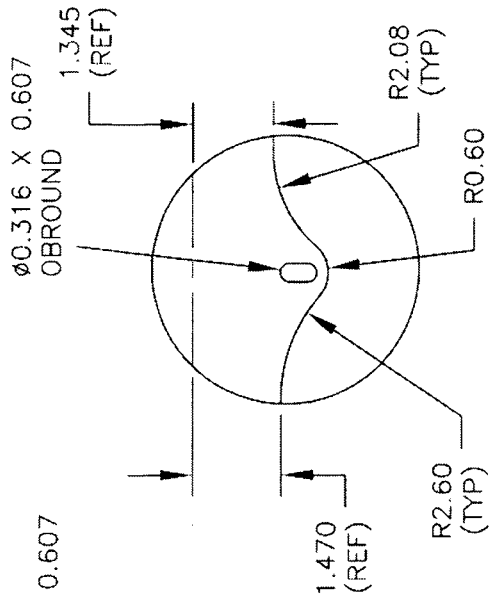
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



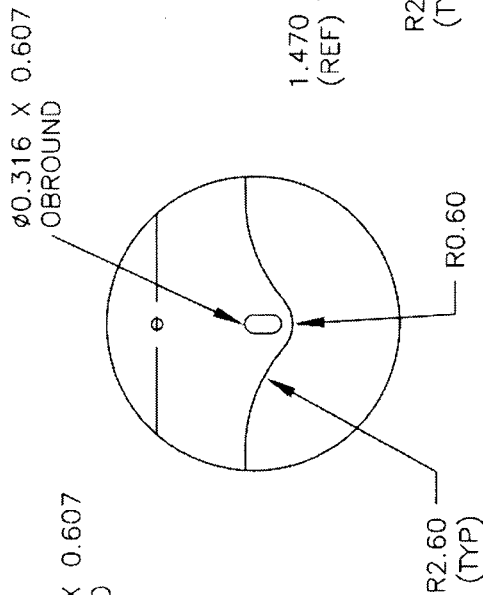
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

RELEASED
15 09 30

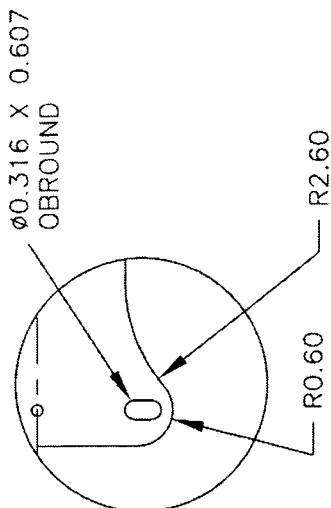
51213



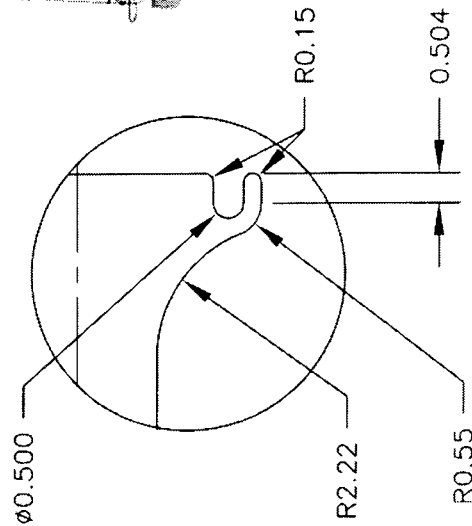
DETAIL J



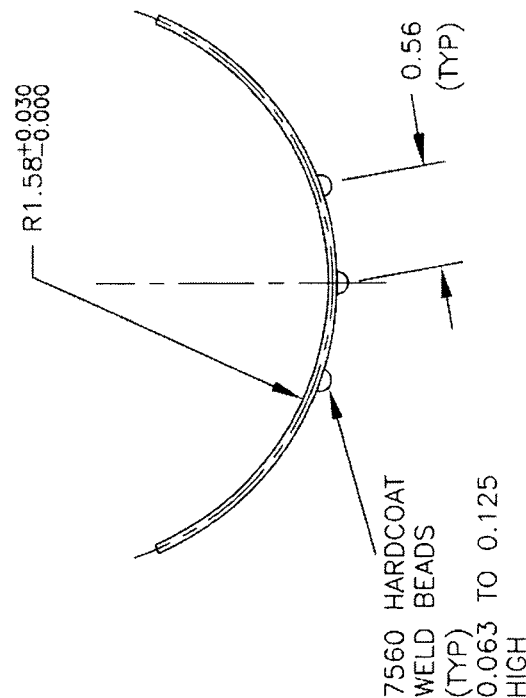
DETAIL F



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

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